

Abstract

This invention relates to a threaded joint for steel pipes which comprises a pin and a box each having a contact surface including a threaded portion and an unthreaded metal contact portion and which can be prevented from galling during repeated fastening and loosening without application of a compound grease. A solid lubricant coating which comprises a lubricating powder such as molybdenum disulfide and a resin binder is formed on the contact surface of at least one of the pin and the box. The coating is formed by applying a coating fluid and drying the applied coating by first stage heating in the temperature range of from 70 °C to 150 °C and second stage heating in the range of from higher than 150 °C to 380 °C. The resulting solid lubricant coating has a hardness of 70 - 140 on the Rockwell M scale and an adhesive strength of at least 500 N/m as determined by the SAICAS (Surface And Interfacial Cutting Analysis System) method, and it exhibits excellent galling resistance even in the environment of high-temperature oil wells. Inclusion of ultraviolet screening fine particles such as titanium oxide fine particles in the solid lubricant coating increases the rust preventing properties of the threaded joint.